

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008090**Date Inspected:** 12-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wan Wen Zhong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) & the weld designations reviewed are as follows:

Bay 10

Inspection part	Section	Inspection Area.
-----------------	---------	------------------

NSD1-FDSA4-3A/C-2A/B;6A/B	North Tower; Lift-4; Skin-D	Bay-10
---------------------------	-----------------------------	--------

NSD1-FCSA4-1A/C-53A/B;54A/B;55A/B	North Tower; Lift-4; Skin-C	Bay-10
-----------------------------------	-----------------------------	--------

Bay 06

SMAW-Strut Connection Plates.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint WD1-A305-77M-1-22,26. Welder is identified as 068924/037932. ZPMC QCI-CWI is identified as Yu Dong Ping and QCI as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS- B-T-2113.

Bay 10

SAW

SAW welding of weld joint ED1-A6003-1-3B; A6003-2-3B; A6003-3-3B; A6003-4-3B; located on East Tower. Welder is identified as 051413. ZPMC QCI-CWI is identified as Wan Wen Zhong and QCI as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

FCAW – Strut connection angle plates.

1)FCAW welding of weld joint SD1-SA230-28M-1-1A located on South Tower. Welder is identified as 0503060. ZPMC QCI-CWI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-TC-U5b-S-2.

Doubler Plate welding:

2)FCAW welding of weld joint SSD1-FASA4-1B/E-5-26 located on South Tower; Lift-4; Skin-A. Welding of Skin-A to Doubler plates is in progress. Welder is identified as 203977/057244. ZPMC QCI-CWI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

Bay 11

SAW

SAW welding of weld joint WD1-A6001-6-1B; A6001-6-3A; A6001-7-1B; A6001-7-3A; A6001-8-1B located on West Tower. Welder is identified as 047304. ZPMC QCI-CWI is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045., who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Rao,Gady	Quality Assurance Inspector
----------------------	----------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------